

Date: Thursday, 19/06/2008 9:53:39 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: TOP PANEL ASS'Y		
Job Number	: 39949			Part Number	: D365011		
Estimate Number	: 13135			Drawing Number	: D3650 REV.B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 19/06/2008	S.O. No. :		Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 02/07/2008	Qty:	2 Um: Each
Previous Run	: 37911						
Written By	:						
Checked & Approved By	: JUL 08 6.19						
Comment	: Est Rev:B ECN 1113P 08-01-22 DD						
	Est Rev:C ecn1162 08-04-02 DD verified by: EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S26GA	304/316 0.018 SHEET Comment: Qty.: 0.0193 sf(s)/Unit Total : 0.0386 sf(s) 304/316 SS sheet 26 ga (0.018" thick) Batch: 108415 B 8-6-26
2.0	WATER JET	FLOW WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D3650 Dwg Rev: B B 8-6-26 Prog Rev: B 2-Deburr if necessary → 08/06/26 ⑤ Am
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE Comment: INSPECT PARTS AS THEY COME OFF MACHINE B 8-6-26
4.0	QC8	SECOND CHECK Comment: SECOND CHECK S 08/06/26 ⑥ Am
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 Comment: Bend as per dwg D3650 B 8-6-26 ⑦ Am

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 19/06/2008 9:53:39 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOP PANEL ASS'Y

Job Number: 39949

Part Number: D365011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	QC5	INSPECT WORK TO CURRENT STEP
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S 08/07/10 48

Comment: INSPECT WORK TO CURRENT STEP

7.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: _____

P1 08-07-15 (5)

8.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------



08/07/10 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39949
Description: FILLER PLATE	Part Number:	D 3650-11
Inspection Dwg:	Rev: B	Page 1 of 1

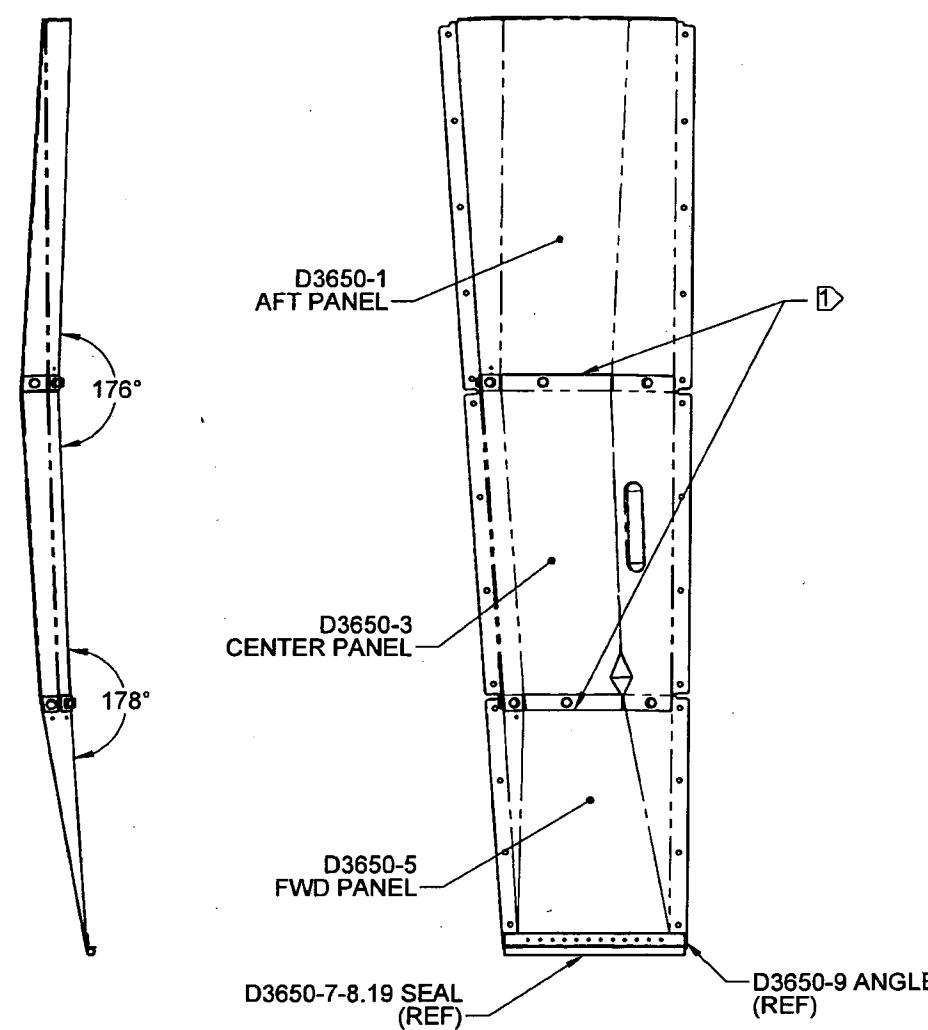
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	HB	Audited by:	S	Prototype Approval:	✓
Date:	8-6-26	Date:	05/06/26	Date:	5

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

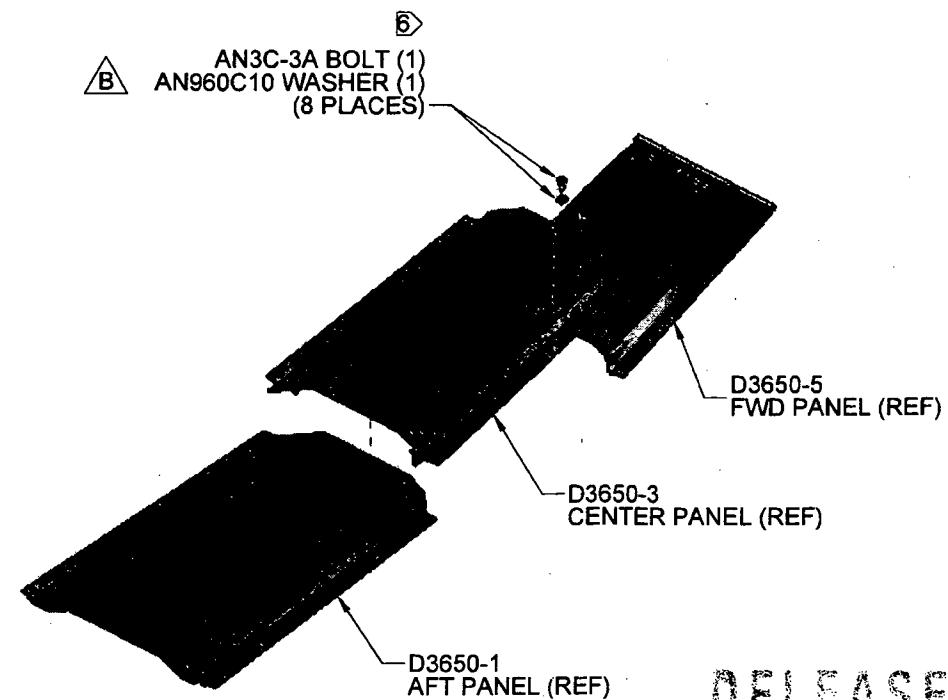
8 7 6 5 4 3 2 1



D3650-041 TUNNEL TOP PANEL ASSEMBLY

NOTES:

- 1) SEAL ALL MATING SURFACES AND ALL GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: NONE
- 6) TORQUE FASTENERS 15 TO 25 in-lb
- 7) WEIGHT: 3.3 lbs



RELEASED
08-03-17/MQ

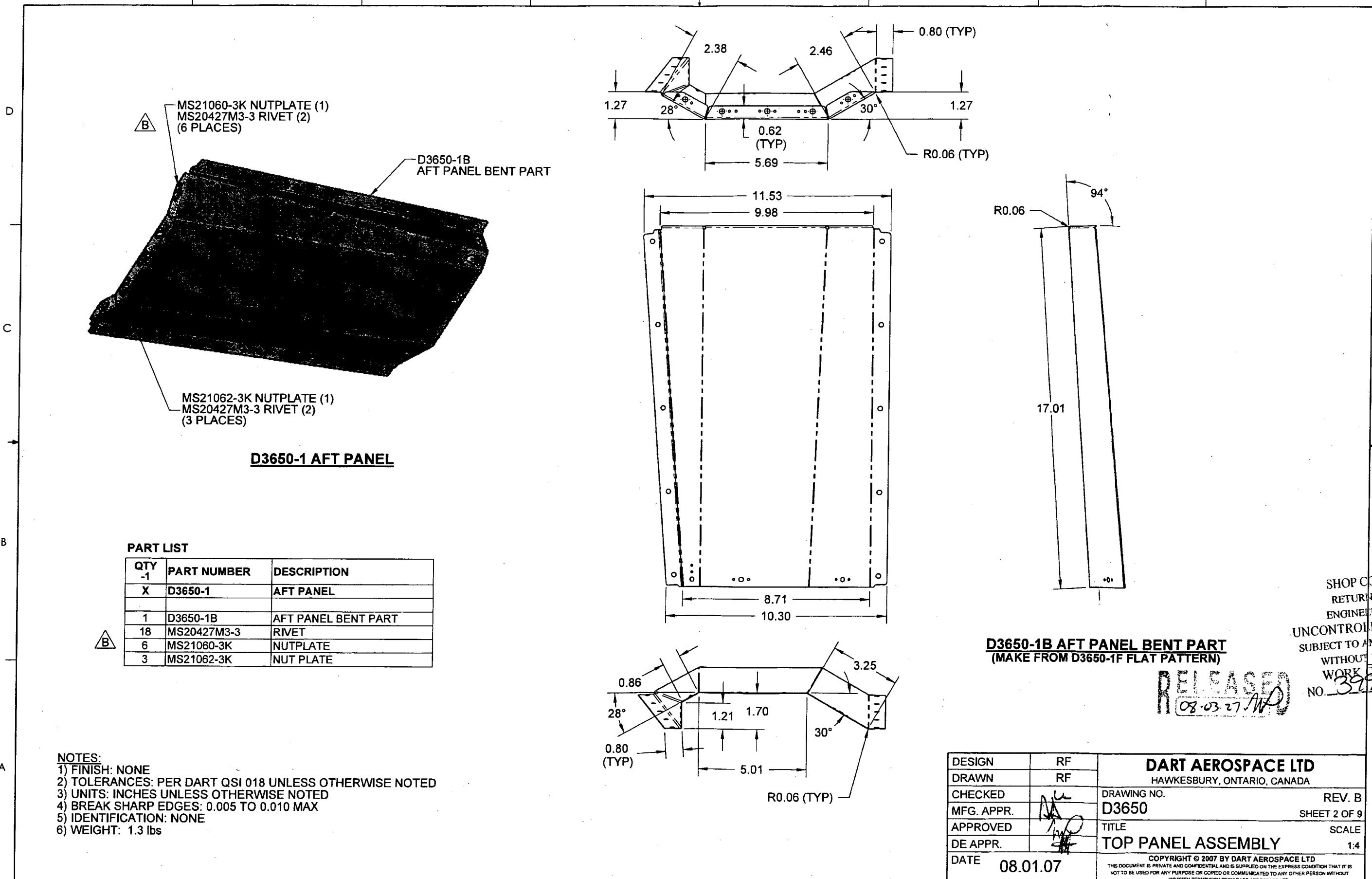
PART LIST

QTY	PART NUMBER	DESCRIPTION
-041	D3650-041	TUNNEL TOP PANEL ASSEMBLY
X		
1	D3650-1	AFT PANEL
1	D3650-3	CENTER PANEL
1	D3650-5	FWD PANEL
8	AN3C-3A	BOLT
8	AN960C10	WASHER

B	SHEETS 1, 2 & 7: UPDATED FASTENER QUANTITIES; UPDATED VIEWS SHEETS 3 & 8: REMOVED/RELOCATED HOLES; UPDATED VIEWS SHEET 4: 1.8 WAS 1.5; 1.0 WAS 0.8; UPDATED VIEW; ADDED NOTE 8 SHEET 5: REMOVED NOTE IN C6 & ASSOCIATED DIMS; UPDATED VIEWS SHEET 6: REMOVED/RELOCATED HOLES & ADDED CUTOUT TO D3650-3F; MOVED D3650-11-11F TO SHEET 9; ADDED DETAIL I SHEET 9: RELOCATED D3650-11-11F FROM SHEET 6; UPDATED DIMS OF D3650-11-11F	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	MM	D3650	SHEET 1 OF 9
APPROVED	MM	TITLE	SCALE
DE APPR.	MM	TOP PANEL ASSEMBLY	1:8
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NO. 399401

8 7 6 5 4 3 2 1



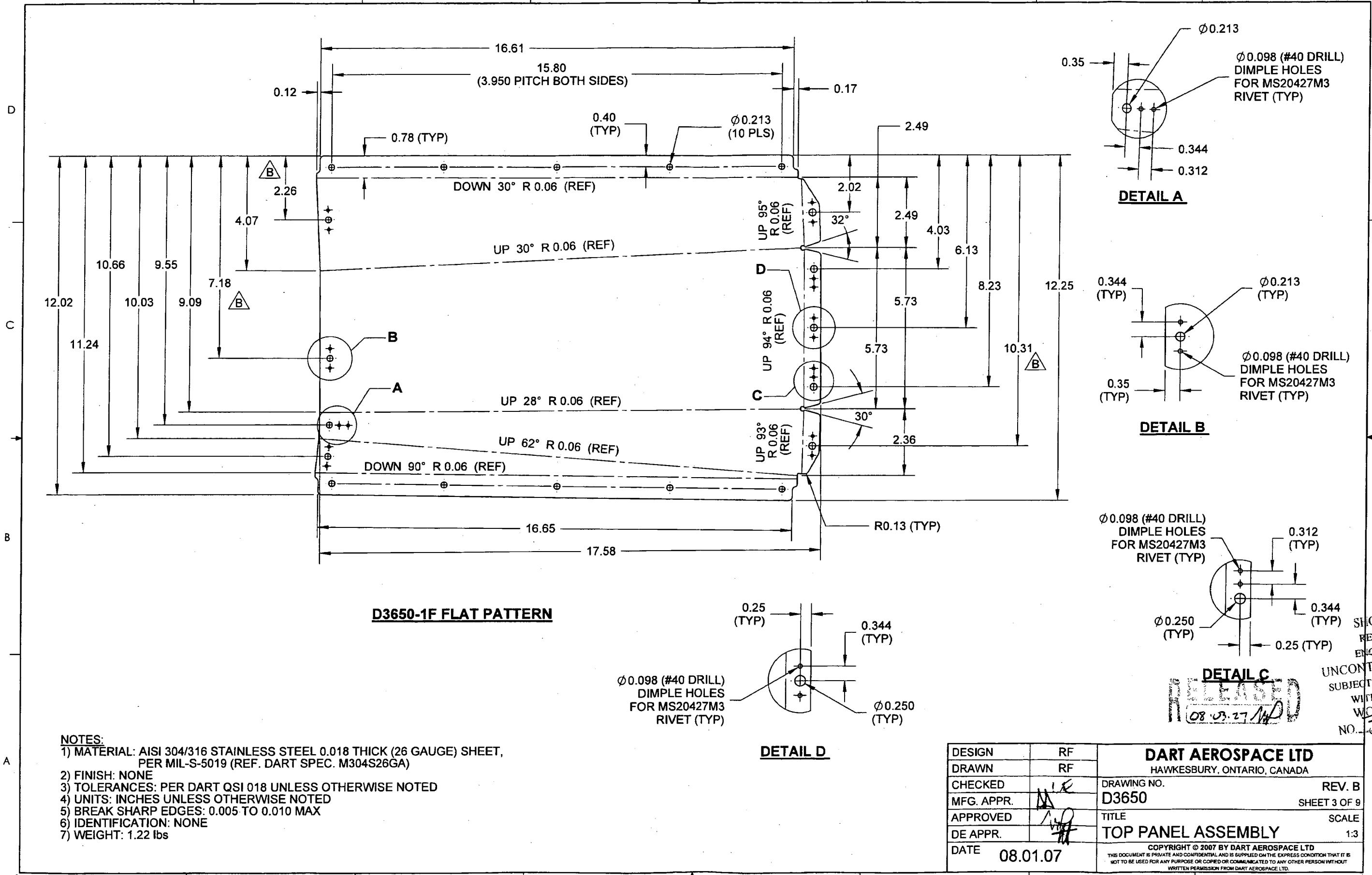
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C

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8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

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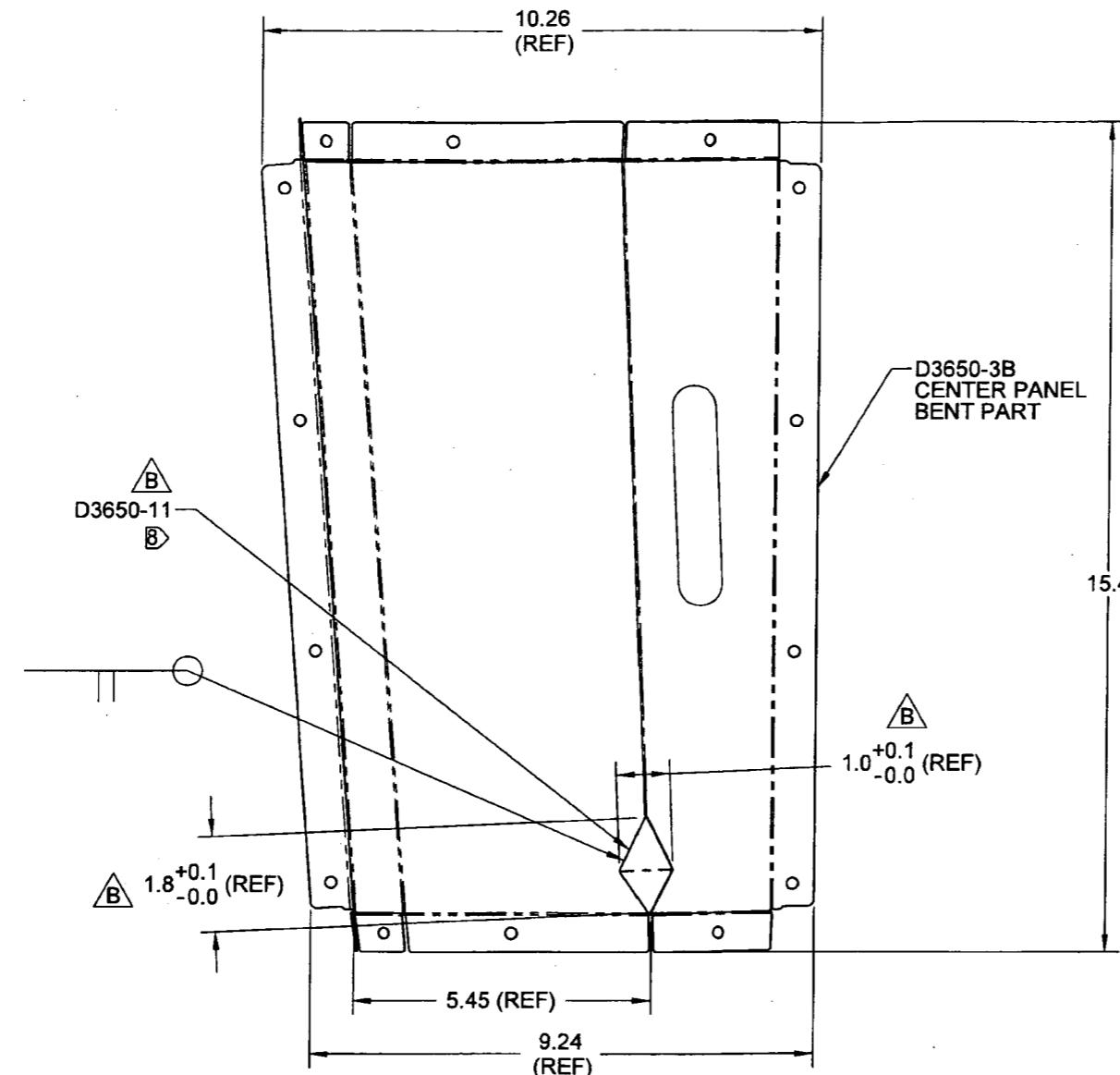
C

B

B

A

A



D3650-3 CENTER PANEL

NOTES:

- 1) WELD PER QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.0 lb
- 8) TRIM D3650-11 TO FIT AS REQUIRED



PART LIST

QTY	PART NUMBER	DESCRIPTION
3	X D3650-3	CENTER PANEL
1	D3650-3B	CENTER PANEL BENT PART
1	D3650-11	FILLER PLATE

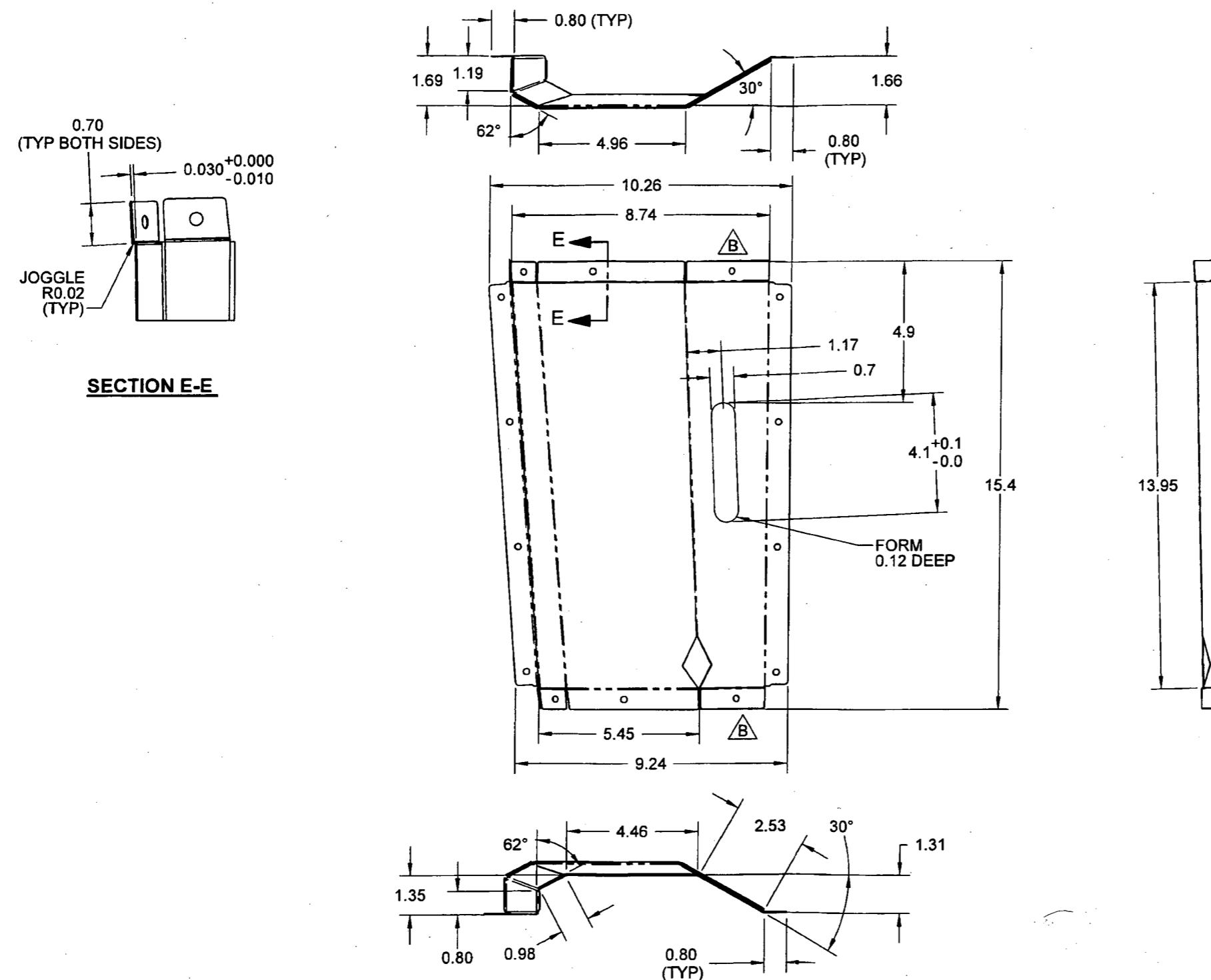
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MFG. APPR.	DA	REV. B
APPROVED	MF	SHEET 4 OF 9
DE APPR.	MF	TITLE
DATE	08.01.07	SCALE
		TOP PANEL ASSEMBLY
		1:3

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8 7 6 5 4 3 2 1 .



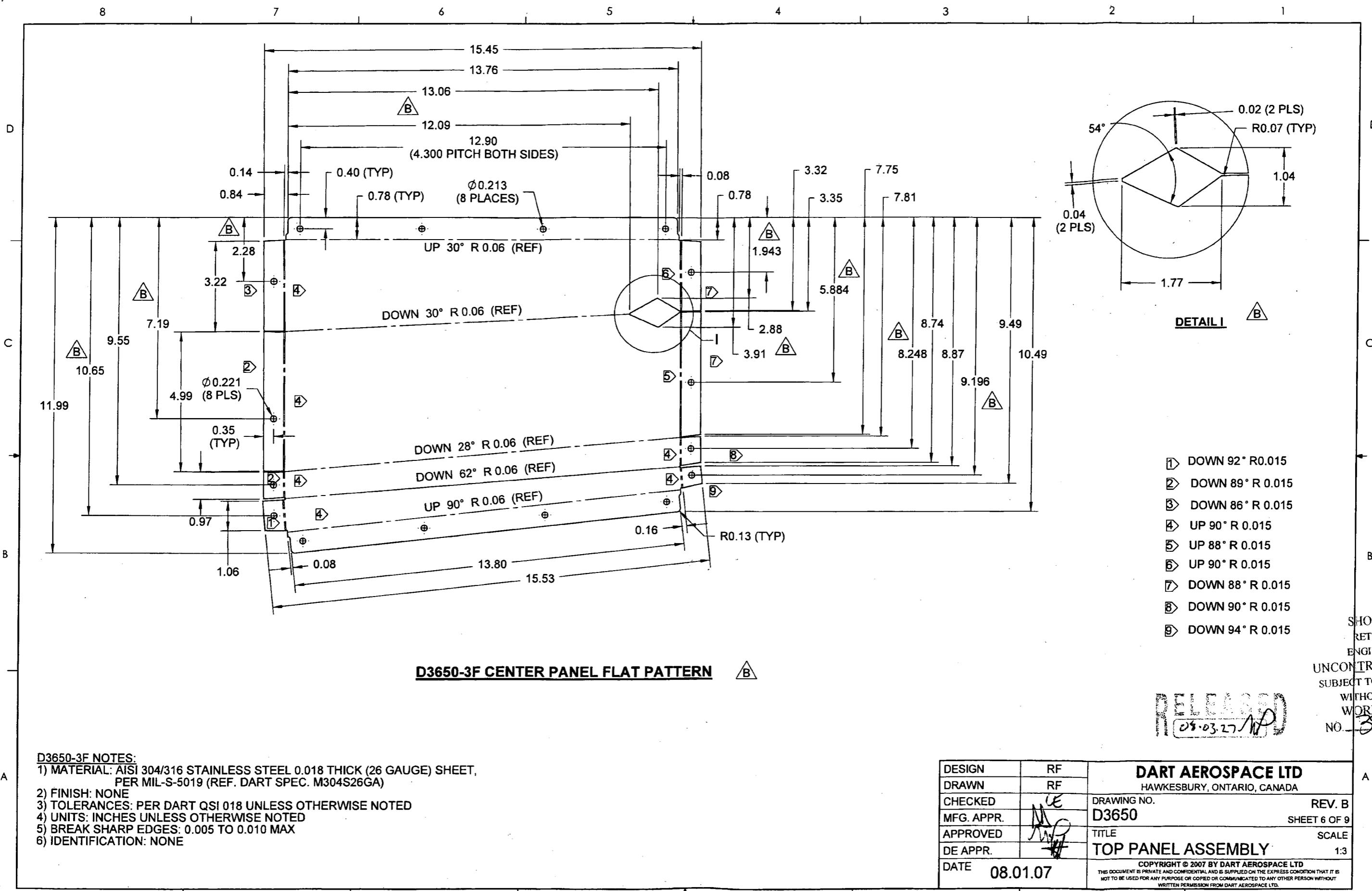
NOTES:
1) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE

D3650-3B CENTER PANEL BENT PART
(MAKE FROM D3650-3F FLAT PATTERN)

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08-03-27/10

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MFG. APPR.	<i>AA</i>	D3650	SHEET 5 OF 9
APPROVED	<i>W</i>	TITLE	SCALE
DE APPR.	<i>W</i>	TOP PANEL ASSEMBLY	
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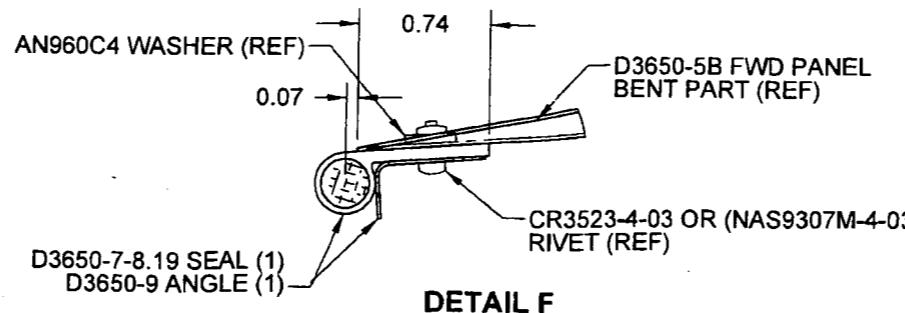
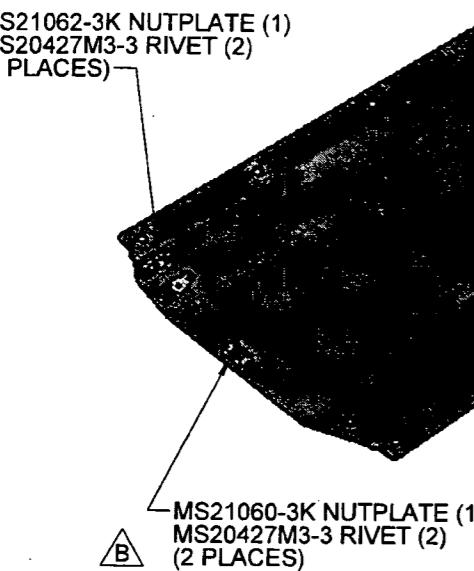
D3650-3F NOTES:

- 1) MATERIAL:** AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET
PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
 - 2) FINISH:** NONE
 - 3) TOLERANCES:** PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS:** INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES:** 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION:** NONE

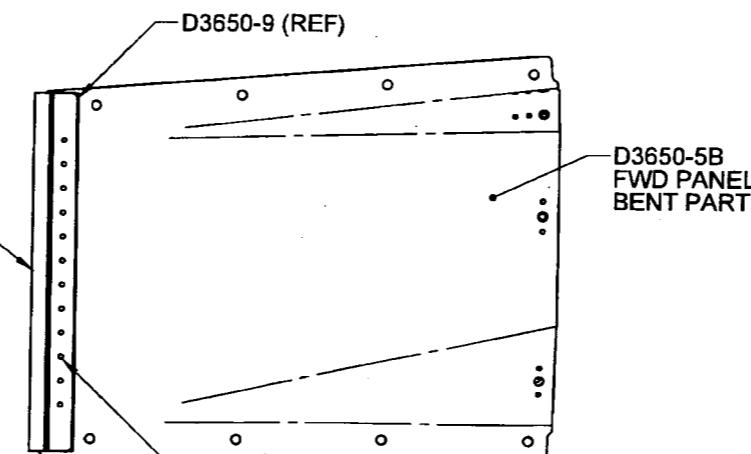
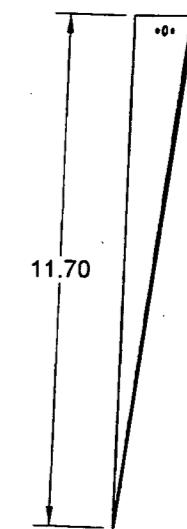
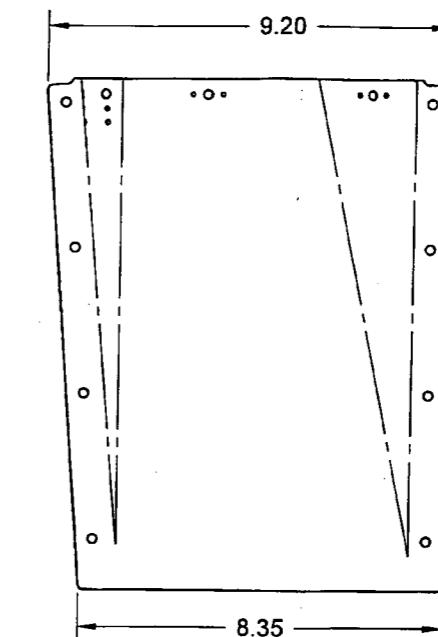
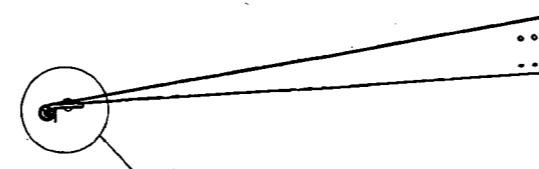
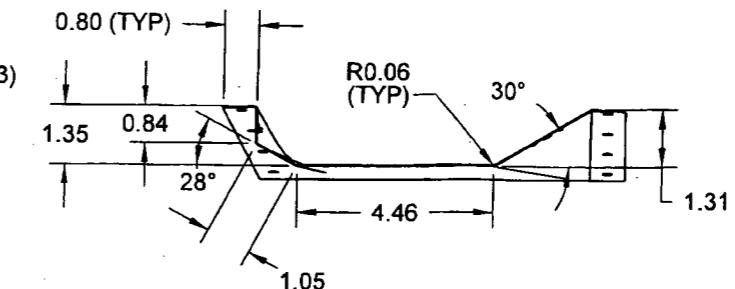
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MFG. APPR.	<i>M</i>	D3650	SHEET 6 OF 9
APPROVED	<i>W</i>	TITLE	SCALE
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DETAIL F



CENTRE D3650-7-9 ON D3650-5B &
TRANSFER Ø0.129 (#30 DRILL) HOLES
FROM D3650-9 TO D3650-7 & D3650-5B
AS SHOWN
INSTALL
CR3523-4-03 OR NAS9307M-4-03 RIVET (1)
AN960C4 WASHER (1)
(12 PLACES)

**D3650-5B FWD PANEL BENT PART
(MAKE FROM D3650-5F FLAT PATTERN)**

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PART LIST

QTY -5	PART NUMBER	DESCRIPTION
X	D3650-5	FWD PANEL
1	D3650-5B	FWD PANEL BENT PART
1	D3650-7-8.19	SEAL
1	D3650-9	ANGLE
12	AN960C4	WASHER
12	CR3523-4-03 or NAS9307M-4-03	RIVET
8	MS20427M3-3	RIVET
2	MS21060-3K	NUTPLATE
2	MS21062-3K	NUTPLATE

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.8 lbs

D3650-5 FWD PANEL

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	LE	
MFG. APPR.	DA	
APPROVED	MC	
DE APPR.	HC	
DATE	08.01.07	REV. B DRAWING NO. D3650 SHEET 7 OF 9 TITLE TOP PANEL ASSEMBLY SCALE 1:4 COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

